



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3610

Job Sheet 200587



Part No: 646.3610

Job Qty: 10 pcs

Part Name: Filler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: 646.3600 REV.NC IPP REV:A 18.03.06 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
105	Bandsaw - 1	10 pcs	10/4/19	10/4/19	0.00	0.50	Bandsaw - 1	
110	HAAS 4 Axis - B4B	10 pcs	10/4/19	10/4/19	0.20	3.23	HAAS - 1 - B4B	
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
120	QC 2	10 pcs	10/4/19	10/4/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	



Container No: S230345



Part: 646.3610

Job No: 200587

Serial No/Batch: S230345

Revision: NC

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/09/19

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				QC 2 - 8		
				QC 2 - 66		
				QC 2 - 64		MM 2019/11/09
				QC 2 - 65		
				QC 2 - 5		
				QC 2 - 71		
				QC 2 - 73		
				QC 2 - 69		
130	QC 8	10 pcs	10/4/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	19-11-09
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
140	Outsource - 4 - Anodize	10 pcs	10/4/19		ATG001-VC	5 19-11-13
150	Packaging 2-1 - Receive - B4B	10 pcs	10/4/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	19-11-13
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	

					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
155 QC 6	10 pcs	10/4/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	JAN 20 2020
					QC 6 - 61	DAS 68
					QC 6 - 40	9-89
					QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	10 pcs	10/4/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	10 pcs	10/4/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 105 - (Bandsaw) Cut blanks at 4.90"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per DWG AND FOLIO FB493 DWG REV: N/c FOLIO

REV: AA 2- deburr and break all sharp edges

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Issue P/O to ATG : 48093 1- Hard Anodize Black and Prime as per Dwg 646.3600

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.000	6061-T6 Bar .750 X 1.00	4.2000 ft (.42 ea)	105-Bandsaw - 1	<u>5224650</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-Bandsaw - 1	M6061T6B0.750X01.000	4	12	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Filler	4.69inches $\pm$ 0.03	4.72 4.66		
2	Filler	3.53inches $\pm$ 0.03	3.56 3.50		
3	Filler	0.600inches $\pm$ 0.030	0.630 0.570		
4	Filler	0.63inches $\pm$ 0.03	0.66 0.60		
5	Filler	0.300inches $\pm$ 0.010	0.310 0.290		
6	Filler	0.375inches $\pm$ 0.010	0.385 0.365		
7	Filler	2.400inches $\pm$ 0.002	2.402 2.398		
8	Filler	0.670inches $\pm$ 0.002	0.672 0.668		
9	Filler	27.500Degrees $\pm$ 0.500	28.000 27.000	Angle	
10	Filler	0.209inches + 0.005 - 0.001	0.214 0.208		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045093



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045093

PO Date: 11/13/19

Due Date: 11/29/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-22

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181338	647.7819	647.7800 Rev A	Cross Bracket Fwd : Various STC's Issue P/O to ATG: HARD ANODIZE COLOR BLACK, AND PRIME AS PER DWG 647.7819	Firmed X5	-	11/29/19	5 pcs	0 pcs	5 pcs	\$12.27/pcs	\$61.35
Line Item Note ***5 pcs. RUSH** 181338-A X 35 6107-2-2019 NOV 2 2 2019												
					Firmed	-	11/29/19	35 pcs	0 pcs	35 pcs	\$12.27/pcs	\$429.45
Sub Total:								40	0	40		\$490.80
2	202746	647.1812	647.1800 Rev NC	Shim : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed X60	-	11/21/19	60 pcs	0 pcs	60 pcs	\$7.87/pcs	\$472.20
Line Item Note ***10 pcs. RUSH*** 6107-2-2019 NOV 2 2 2019												
3	200587	646.3610	646.3600 Rev NC	Filler : Various STC's Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed X20	-	11/29/19	20 pcs	0 pcs	20 pcs	\$7.62/pcs	\$152.40
NOV 2 8 2019												



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PURCHASE ORDER **POHB045093**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	200102	RB6798089-1	6798089 Rev A	Plate Outsource process- Anodize per QSI017 4.1.10.1 -Issue P/O -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS- 2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	11/29/19	2 pcs	0 pcs	2 pcs	\$41.02/pcs	\$82.04

Grand Total: \$1,197.44

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/22/19 8:48 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919032

Date: 27-Nov-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
5 ea	Part: 647.7819 Cross Bracket Fwd Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: _____ Expiry Date: _____ Job: 26462 Line: 1 PO: POHB045093	Rev: A	
20 ea	Part: 646.3610 Filler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# 120908 Expiry Date: 10/20 Job: 26464 Line: 3 PO: POHB045093	Rev: N/C	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>NOV 27 2019</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ Made in Canada.			

DAS
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9-89

RECEIVED

NOV 27 2019

DART AEROSPACE LTD.

